

# Work Order ID 50764

July 21, 2009 2:40:19 PM



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Item ID: D2596

Accept



Setup Start



Revision ID: D

Stop

Item Name: Web, 205 Skidtube

Start Date: 07/22/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 07/31/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-21 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2596	Rev D

100 0.00

Skidtubes

Skidtubes 0.00

Memo  
1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes  
#30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr

10 ✓ AM 9-7-22

110 0.00

Chemical Conversion Coat per QSI005 4.1

HandFinish 0.00

Memo Hand Finishing

10 ✓ AM 9-7-22

120 0.00

QC5- Inspect part completeness to step on W/O

QC 0.00

Memo Quality Control

⇒ Solat 22

(NO) ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 50764**

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Customer:

**Reference:**

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description**

130

Identify as per dwg & Stock Location: L-G

Packaging

Packaging

140



QC

Quality Control

**Set Up/  
Run Hours****Draw  
Number****Draw  
Rev.****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

0.00

0.00

10



AWM 7-7-22

QC21- Final Inspection - Work Order Release

0.00

Memo

09/07/24 JJ

W 07/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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# Picklist Print

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Work Order ID: 50764



Parent Item: D2596RevD

Parent Item Name: Web, 205 Skidtube

Start Date: 07/22/2009

Required Date: 07/31/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-3-100RevU/R		Manufactured	No			100	Each	0.0000	10.0000		B-40196 -AWMG-7-22	(10)

Ext'n - I Beam Web 4"

Barcode for Component Item ID D2500-3-100RevU/R



Barcode for Component Item Name Web, 205 Skidtube

W/O:		WORK ORDER CHANGES					
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**DART**

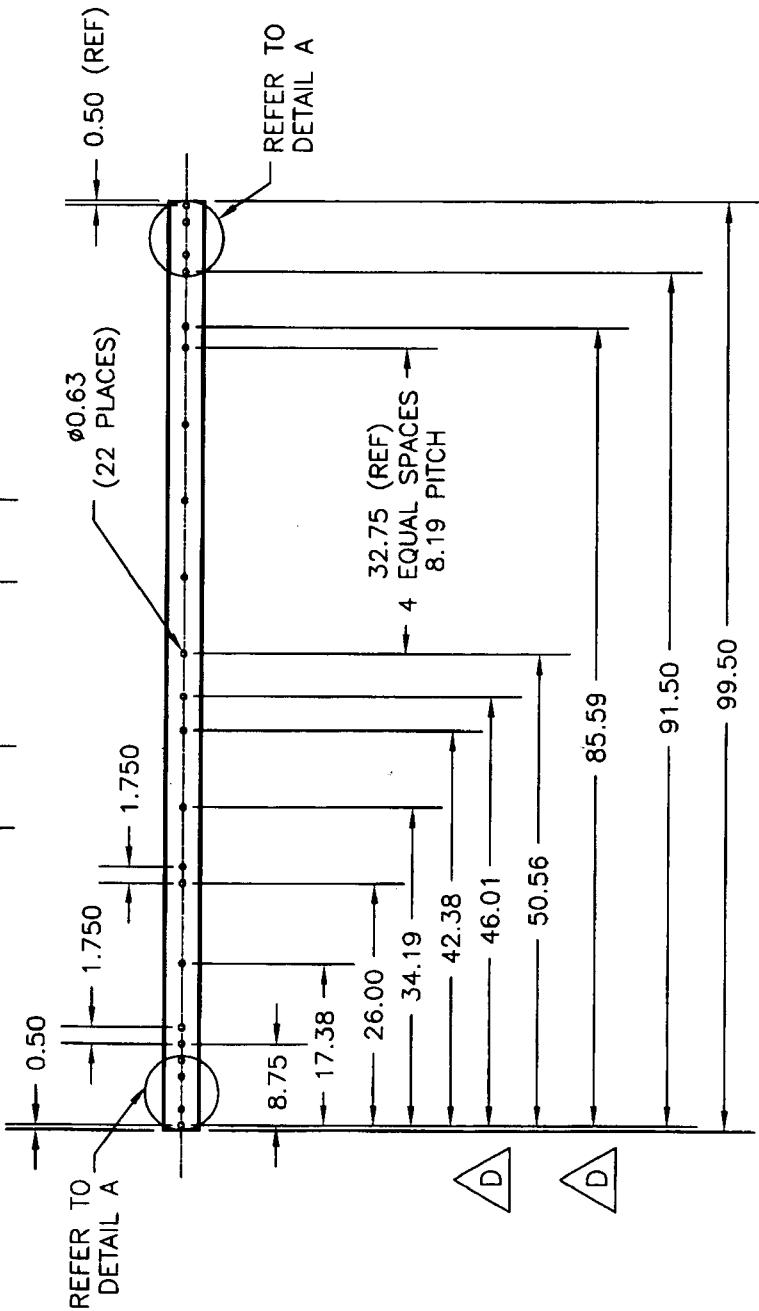
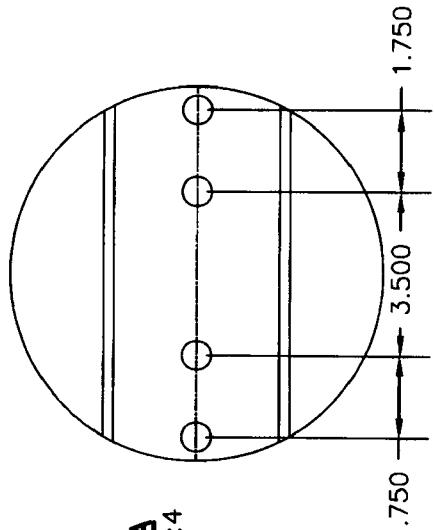
DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JH</i>	APPROVED <i>JH</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1
DATE 07.04.17		TITLE 205 WEB	SCALE 1:20
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	

RELEASED  
07-06-28

07.06.08 #

# 90764

**DETAIL A**  
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) ALL DIMENSIONS ARE IN INCHES  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) DEBURR SHARP EDGES 0.010 TO 0.020

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